

Date: Tuesday, 3/11/2008 10:28:22 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARING ASSEMBLY		
Job Number	: 37774					
Estimate Number	: 11136					
P.O. Number	:			Part Number	: D3183045	
This Issue	: 3/11/2008		S.O. No. :	Drawing Number	: D3183 REV C1	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: C1	
Previous Run	: 36638			Material	:	
Written By	:			Due Date	: 3/30/2008	
Checked & Approved By	:			Qty:	30 Um: Each	
Comment	: Est A 04.02.18 New issue KJ/DS					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MDELRINR1000	Delrin Round Bar 1"	
		Comment: Qty.: 0.0350 f(s)/Unit Total : 1.0490 f(s) Delrin Round Bar 1" Material: Ø1.00 Delrin Rod (M-DELRIN-R1.000) Identify as D3183-9 Batch: M103164	
			J.F. 08/03/23
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Turn D3183-9 Cap as per Folio FA388 Deburr	
			J.F. 08/03/23
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
			J.F. 08/03/23
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
			J.F. 08/03/25
5.0	D31835	Bearing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s) Pick: Qty Part Number Description Batch	
		1 D3183-5 Bearing	
			B-38138
			S.B. 08/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

x32

mf 08/04/14

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(- 08/04/14) x32

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

75

JS 08/04/14 (R32)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/15 JH

Job Completion



-mf 08-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37774
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183 Rev: C1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article | Prototype

Measured by:	J.F.	Audited by:	<i>RJ</i>	Prototype Approval:	N/A
Date:	08/03/23	Date:	08/03/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3183-045)	KJ/RF	
B	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>#</i>	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3183
DATE 04.02.17	TITLE BRACKET ASSEMBLY	REV. C SCALE 1:1

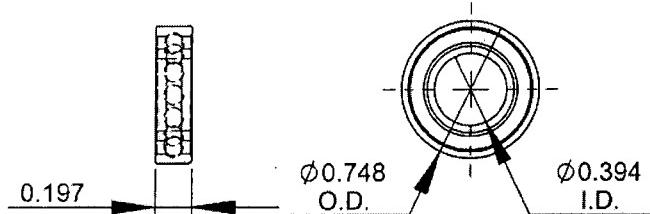
RELEASED04.03.01 *[Signature]*

D3121-21 BOLT (1)

D3183-045 BEARING ASSEMBLY (1)

D3121-21 BOLT (1)
D3183-045 BEARING ASSEMBLY (1)D3183-1 BRACKET FOR -041 (SHOWN)
OR
D3183-2 BRACKET FOR -042 (OPPOSITE)
OR
D3183-3 BRACKET FOR -043 (SIMILAR)
OR
D3183-4 BRACKET FOR -044 (SIMILAR)

- D3183-041 BRACKET ASSEMBLY (SHOWN)**
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

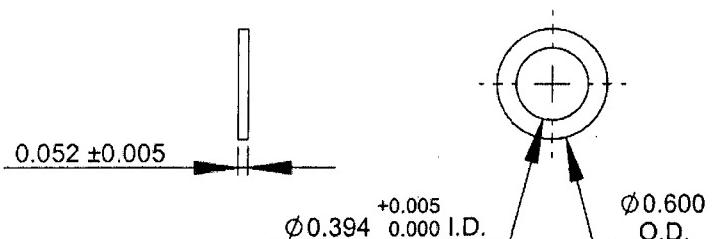
- 1) SINGLE ROW, DEEP GROOVE, SHOP COPY CONRAD TYPE, SHIELDED
 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
 3) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 37774

D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R)
ANNEALED
 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES

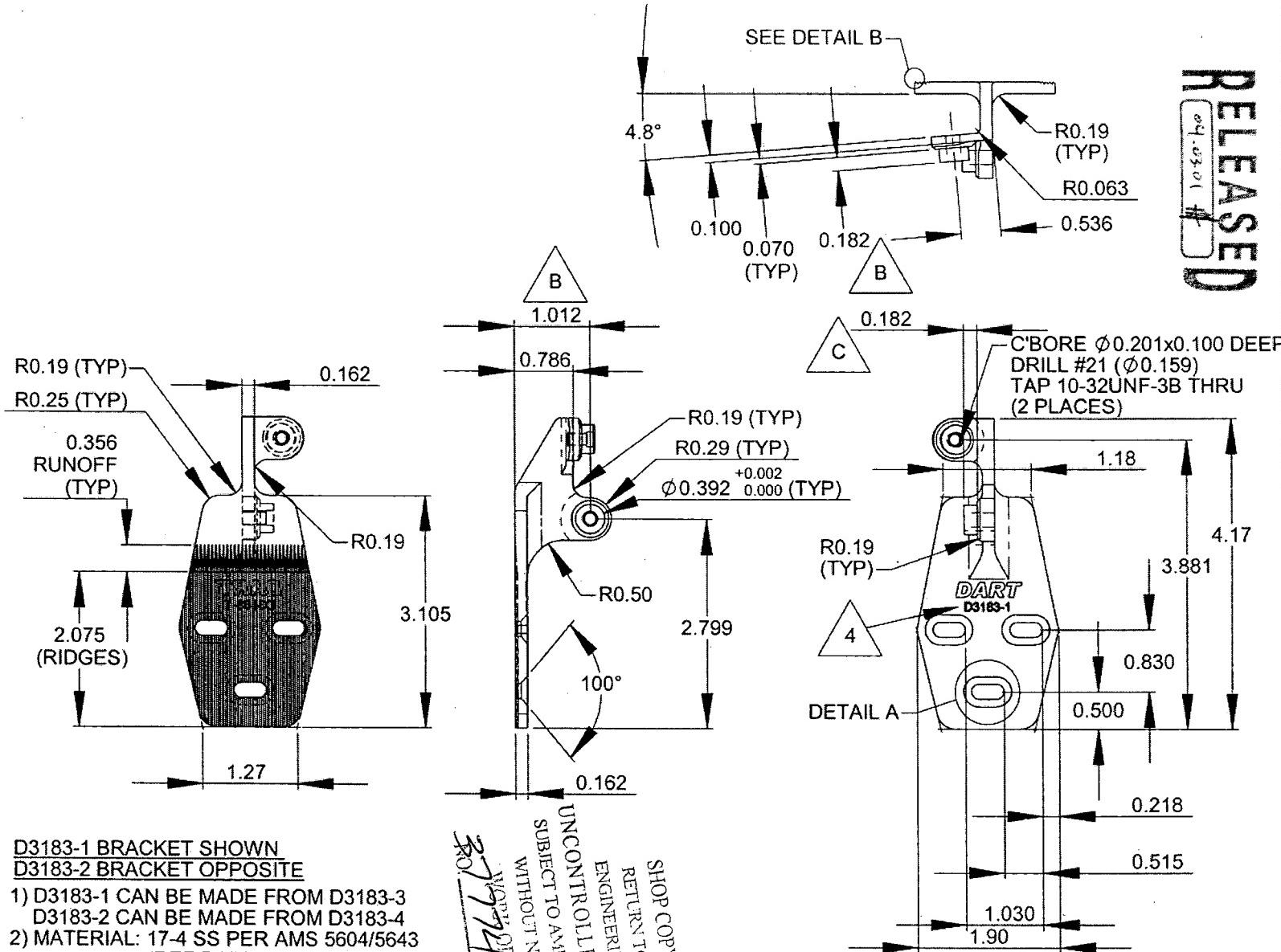


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D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4

2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ENGRAVE DART P/N & LOGO AS SHOWN

5) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

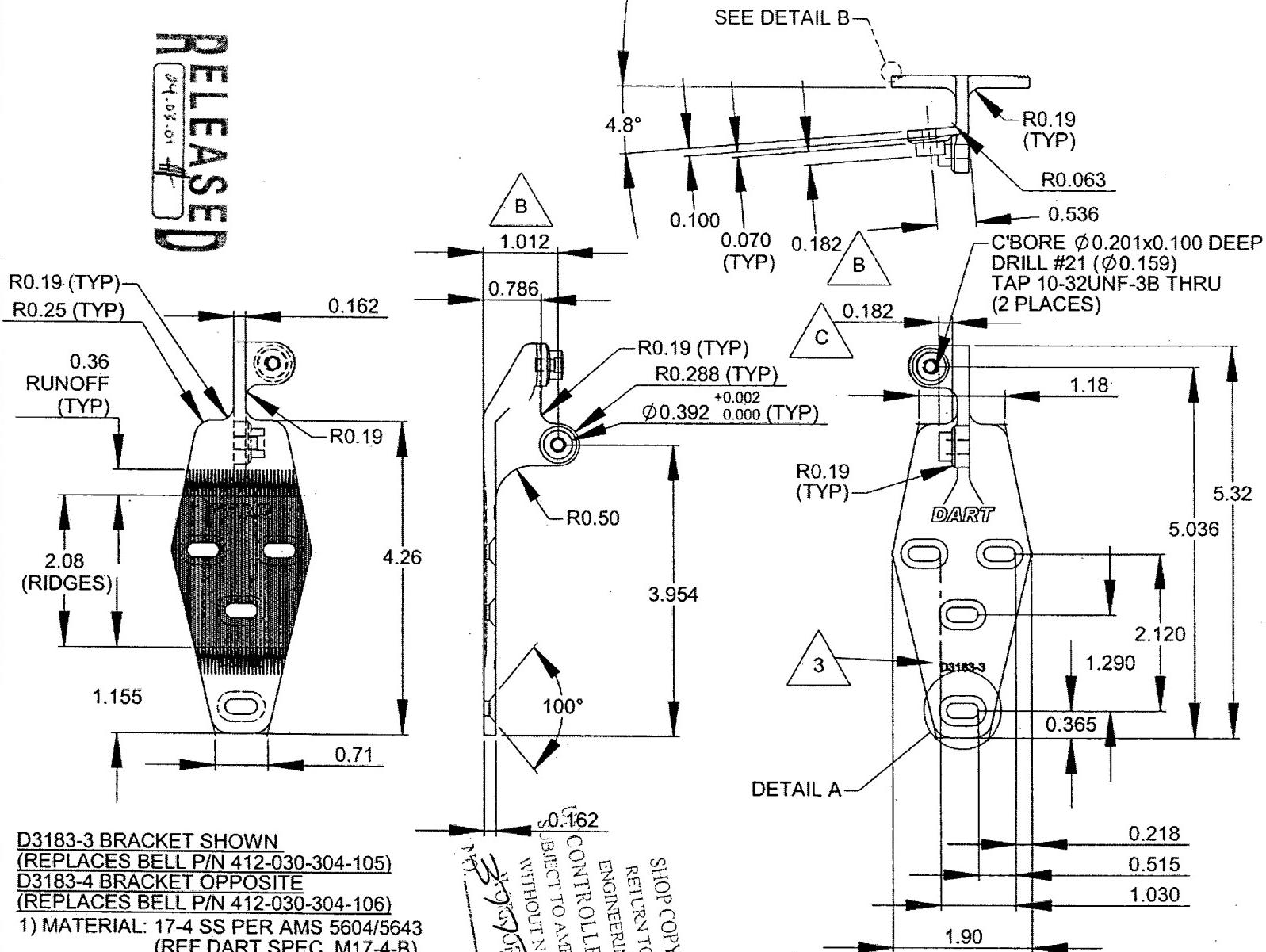
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NOV 20 1974
307-9774
ksj

DESIGN		DRAWN BY <i>(Signature)</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED <i>(Signature)</i>	APPROVED <i>(Signature)</i>		
DATE 04.02.17		TITLE BRACKET ASSEMBLY	DRAWING NO. D3183
		SCALE 1:2	REV. C SHEET 2 OF 4

DART



DESIGN	DRAWN BY	<i>JP</i>	DART AEROSPACE LTD
CHECKED	APPROVED	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	D3183	REV. C
TITLE	SHEET 3 OF 4	BRACKET ASSEMBLY	SCALE 1:2



DART

DESIGN	DRAWN BY	IP
CHECKED	APPROVED	PF
DATE	04.02.17	04.02.17

DART AEROSPACE LTD

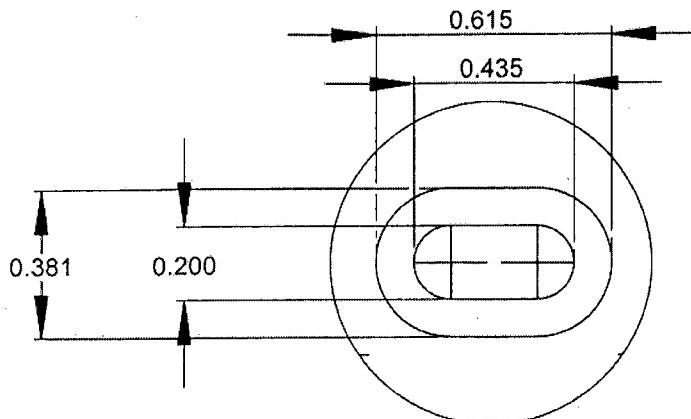
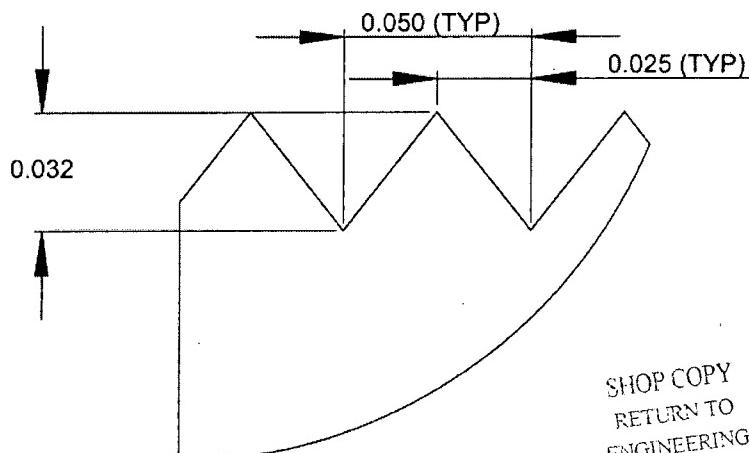
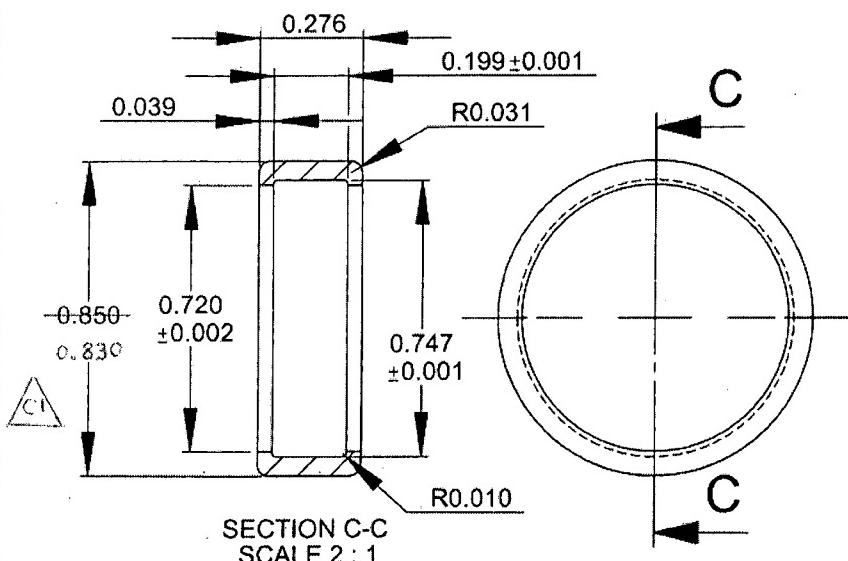
HAWKESBURY, ONTARIO, CANADA

REV. C

SHEET 4 OF 4

SCALE

1:1

DETAIL A (2 : 1)**RELEASED**
04-03-01DETAIL B (20 : 1)**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00 (REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO 37774

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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